



## **Commodity Specification**

# **GROUND TURKEY, TURKEY BURGERS, AND TURKEY SAUSAGE**

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## I. GENERAL

Ground turkey, turkey burgers, and turkey sausage (commodity) produced under this Specification will be packaged and packed in the following forms as specified in the contract:

Ground Turkey (233540) - Frozen ground turkey packaged in four 10-pound (4.54 kg) packages to a net weight of 40 pounds (18.14 kg) in each fiberboard shipping container. A purchase unit will consist of 1,000 shipping containers totaling 40,000 pounds (18,144 kg).

Turkey Burgers (238336) - Frozen turkey burgers packaged 6, 9, 12, or 18 pounds (2.72, 4.08, 5.44, or 8.16 kg) per package in plastic-film bags or pouches to a net weight of 36 pounds (16.33 kg) in each fiberboard shipping container. A purchase unit will consist of 1,000 shipping containers totaling 36,000 pounds (16,329 kg).

Turkey Sausage in Casings (231130) - Frozen turkey sausage packaged in 3- or 5-pound (1.36 or 2.27 kg) packages to a net weight of 30 pounds (13.61 kg) in each fiberboard shipping container. A purchase unit will consist of 1,300 shipping containers totaling 39,000 pounds (17,690 kg).

## II. COMMODITY SPECIFICATIONS

### A. Basic Requirements

1. Date Processed. The commodity must not be processed prior to the date of the contract. The turkey burgers and turkey sausage will be prepared from ground turkey processed in accordance with II.A. through II.C.6., and II.C.8.

2. Origin of Turkeys. The commodity must be produced and processed from ready-to-cook turkeys, turkey parts, boneless parts, meat, and skin (turkey products) which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles turkey products originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for those turkey products to ensure they are not used in the commodities produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, AMS, USDA (grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both the contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the USDA grader or other Government official(s) in accordance with Article 76 of USDA-1.

## II.A.

3. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 C.F.R. Part 381) and be under the supervision of a representative of the USDA's Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 C.F.R. Part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a USDA grader. The USDA grader will be responsible for certification of compliance with the requirements of this Specification for chilled turkey products; formulation, processing, cooling of ground turkey; ground turkey; stuffing into casings; processing ground turkey into turkey burgers; chilling of turkey burgers; turkey burgers; processing ground turkey into turkey sausage; turkey sausage; stuffing turkey sausage into casings; packaging and packing; freezing; labeling and marking; sampling; laboratory results; net weight; and checkloading.

4. Product Temperature. The temperature of turkey products, size-reduced turkey products, ground turkey, turkey burgers, and turkey sausage unless otherwise specified, must comply with 9 C.F.R. § 381.66 throughout all operations including transportation between plants.

5. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

6. Turkey Products From Other Plants. Chilled turkey and turkey products may be transferred or obtained from other plants to produce the ground turkey, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the freshly slaughtered, nonbasted, organoleptic, and other applicable requirements of this Specification as evidenced by USDA certification.

a. Type, class, and specific name of the product, part, boneless part, or meat; date slaughtered; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled turkey and turkey products must be maintained at an internal product temperature not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) when shipped from the origin plant and when received at the destination plant.

### B. Requirements for Turkey Products

1. Sources of Meat and Skin. The ground turkey must be prepared from freshly slaughtered young turkeys. The meat and skin must be from nonbasted carcasses and parts (no solution or ingredients added). No frozen or previously frozen carcasses or parts may be used.

## **II.B.**

2. Time Requirements. The chilled turkey and bone-in, skin-on or skinless turkey parts must be deboned and used in the ground turkey within 7 calendar days after the day the turkeys are slaughtered. Within this 7-day timeframe, deboned meat and skin from turkey and turkey parts must be used in the ground turkey within 36 hours after deboning.

3. Maximum Temperature. The temperature of the carcasses, bone-in or boneless parts, and skin must not exceed 55 °F (12.8 °C) at any time during preparation or processing of these turkey products into ground turkey.

4. Cooling Requirements. Carcasses, bone-in or boneless parts, and skin which are not used in the ground turkey on a continuous basis, must be cooled by an FSIS approved method or cooling media and the internal product temperature continuously lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C).

5. Cooling Medium.

a. Cooling methods approved by FSIS (e.g., use of carbon dioxide (CO<sub>2</sub>) or liquid nitrogen (N<sub>2</sub>)) may be used to maintain the temperature of meat, skin, and parts.

b. Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat, skin, or parts must not be incorporated into the ground turkey. Liquid associated with normal product weepage is acceptable.

6. Requirements for Neck and Crop Skin. Neck skin cannot be used in ground turkey. The fatty blubber, spongy fat, and membranes must be removed from the skin covering the crop area before it can be used.

7. Requirements for Desinewing. The long bone (tibiotarsus) must be removed from the drumsticks before the drumsticks (with or without attached skin) are processed through a desinewer to remove the tendons.

8. Organoleptic Requirements and Defects.

a. Organoleptic requirements. Meat, skin, boneless parts, deboned drumsticks, and parts (bone-in) will be examined on a continuous basis for the organoleptic requirements listed in Table 1 below. Any product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. Defects.

(1) A sample of 10 pieces of meat, skin, boneless parts, deboned drumsticks, and parts (bone-in) will be examined for the defects listed in Table 1 before formulation or size reduction. The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' Sample Plan Level 2 (SPL-2). If the sample has more defects

## II.B.8.

than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

(2) If simultaneous size-reduction and bone removal systems will be used, boneless parts and deboned drumsticks shall be examined for the applicable defects listed in Table 1 except for the presence of bone or bone-like material, hard tendon or tendinous material, or cartilage (gristle).

**Table 1. Organoleptic Requirements and Defects for Meat and Skin**

<b>Organoleptic Requirements:</b>	<b>Criteria:</b> Must be free from rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine, or other off or foreign odors; free of foreign materials (e.g., glass, paper, rubber, metal); must show no evidence of mishandling or deterioration; and must have a bright color with no evidence of dehydration or thawing and refreezing.
<b>Defects - All Meat, Skin, and Parts: (With or Without Attached Skin)</b>	<p><b>A flesh bruise</b> on meat or on a part which exceeds an area equivalent to the area of a circle with a diameter of 0.75 inch (1.91 cm).</p> <p><b>Large blood clots</b> on the meat or on a part which exceed an area equivalent to the area of a circle with a diameter of 0.25 inch (0.64 cm).</p> <p><b>A defect for skin</b> is the presence of feathers, hair, fatty blubber, spongy fat, and membranes.</p> <p><b>A defect for discolorations</b> in the meat or skin is when the aggregate area of all discolorations, which are moderate in intensity exceeds an area equivalent to the area of a circle having a diameter of 1.50 inches (3.81 cm).</p>
<b>Defects - Bone In Parts: (With or Without Attached Skin)</b>	<b>More than one-third</b> of the meat missing on a bone-in part.
<b>Defects - Boneless Drumstick Meat (With or Without Attached Skin)</b>	<b>Bone or</b> bone-like material, except that the knuckle bone (patella) may be present.
<b>Defects - Other Boneless Meat: (With or Without Attached Skin)</b>	<p><b>Bone or</b> bone-like material, hard tendon or tendinous material, ligament or ligamentous material, or cartilage (gristle).</p> <p><b>A boneless thigh with</b> more than one-half of the meat missing.</p>



C. Formulation and Processing Requirements for Ground Turkey

1. Formulas. Ground turkey must be formulated according to one of the following two formulas:

a. Meat and skin basis. Formula based on deboned meat (with or without attached skin) or boneless parts. The maximum amount that can be used in a formula is specified when applicable.

(1) White meat (with or without attached skin). The maximum amount of white meat (with or without attached skin) that can be used in a formula is 30 percent of the total weight of the formula. The white meat may be wing meat or scapula portion. Other white meat trimmed from the frames (white frame meat) may be used. White frame meat is limited to no more than 3 percent of the total weight of the formula.

(2) Dark meat (with or without attached skin). Boneless thighs or boneless and skinless thighs (not more than one-half of meat missing) or desinewed drumstick meat may be used. Dark meat trimmed from the frame (dark frame meat) may be used. Dark frame meat is limited to not more than 2 percent of the total weight of the formula.

b. Bone-in basis. Formula based on bone-in parts (with or without attached skin). The maximum amount of a specific part which can be used in a formula is specified when applicable. These parts are for preparation of ground turkey by mechanically removing the meat and skin directly from the parts and simultaneously reducing the size of the meat and skin (mechanical and simultaneous reduction process).

(1) Drumsticks. Drumsticks may be used.

(2) Thighs. Thighs may be used.

(3) Wings. Wings may be whole wings, the first portions, or attached first and second portions. Wing tips can only be used when they are part of a whole wing. The maximum amount of wings or wing portions which can be used in a formula is 40 percent of the total weight of the formula.

2. Skin. Skin that is attached to the meat or parts may be formulated according to II.C.1. above in natural proportion. Skin that is not attached to the meat must be added in natural proportion in accordance with 9 C.F.R. § 381.117(d). In addition to the skin attached or unattached to the meat or parts, additional skin may be added in amounts exceeding natural proportion (9 C.F.R. § 381.117(d)) provided the finished product is labeled in accordance with section IV.

## II.C.

3. Fat Requirements. The ground turkey must be formulated so the fat content complies with II.G.1.a. for packaged and packed ground turkey or turkey burgers, and II.G.1.b. for packaged and packed turkey sausage.

4. Processing and Size Reduction.

a. Processing. The meat and skin must be processed and blended, as applicable, and reduced in size by equipment and procedures that produce a uniform blend of meat and skin with muscle fibers and strand-like texture, and having the functional properties of ground turkey.

b. Size reduction. Meat and skin for the ground turkey must be reduced in size by one of the following procedures:

(1) Ground turkey and turkey burgers.

(a) Ground through a plate with holes 0.125 inch (1/8 inch) (3.175 mm) in diameter;

(b) Desinewed or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch (1.5 mm to 2.0 mm) in diameter or as required to ensure equivalent removal of tendons present in the meat;

(c) Reduced through a head consisting of a series of screen plates with rectangular-like openings that measure: (a) 0.018 to 0.020 inch by 0.765 to 0.831 inch and (b) 0.018 to 0.020 inch by 0.255 to 0.302 inch. (Measurement of the rectangular-like openings in metric units: (a) 0.4572 to 0.5080 mm by 19.4310 to 21.1074 mm and (b) 0.4572 to 0.5080 mm by 6.4770 to 7.6708 mm.) The screen plates with the smaller openings will be positioned at the exit end of the auger and the number of these screen plates cannot be more than 12 percent of the total number of screen plates in the head; or

(d) Ground through a plate with holes 2 inches (5.08 cm) in diameter followed by size reduction through a stainless steel cylinder or screen with a series of round openings which divide the surface into thirds. Two-thirds (2/3) of the surface will have openings which measure 0.050 inch (1.27 mm). The exit end (the final 1/3) of the surface will be blank (no openings).

For mechanical removal and simultaneous reduction process, the contractor must give the USDA grader the model of the machine, the size of the cylinder screen or screen plates, the number of each size and the sequence of the screen plates which will be used to produce size-reduced meat and skin for use under this Specification. In addition, the contractor must have established control procedures to ensure the cylinder screen or screen plates are in the correct position, the screen plates are in the correct sequence, and that the cylinder screen or screen plates and the auger are aligned and maintained in an operating condition that will

## II.C.4.

continuously produce a product which complies with the texture criteria and other requirements of this Specification. These control procedures must be reviewed and found acceptable by supervisory personnel of the Grading Branch, Poultry Programs, AMS, before size-reduced meat and skin can be used as ground turkey under this Specification.

(2) **Turkey sausage.** Only three size-reduction methods, II.C.4.b.(1)(a), II.C.4.b.(1)(b), and II.C.4.b.(1)(c) above, may be used to produce ground turkey for the turkey sausage.

c. Size reduction equipment. Any bent, broken, or defective blade, cylinder, screen, or plate must be replaced before the size reduction equipment can be used for reducing meat and skin.

d. Reducing size of skin.

(1) Skin, which is removed from the meat, must be reduced in size to approximately the same particle size as the meat before it is added to a formula.

(2) Skin must be processed so its fibrous-like texture is not destroyed. The reduced skin must be blended uniformly with the meat.

e. Unacceptable size-reduced products. Meat and skin which cannot be used in the ground turkey: (1) comminuted meat; (2) meat or skin reduced to an emulsified or pasty consistency; (3) skin processed to a gummy or tacky consistency; (4) skin which does not comply with the requirements of paragraph II.C.4.d. above; (5) meat or skin which developed a discoloration during size-reduction process; or (6) size-reduced meat and skin which has been previously frozen.

5. Cooling Size-Reduced Turkey Products. Cooling methods and medium approved by FSIS (e.g., use of CO<sub>2</sub> or N<sub>2</sub>) may be used before, during, or after size reduction. Ice or ice water must not be used to lower the temperature of the ground product.

6. Temperature of Size-Reduced Turkey Products. Temperature of ground turkey or any size-reduced component of the product (ground, desinewed, or mechanically reduced meat and skin) hereinafter referred to as "ground product" must not exceed 55 °F (12.8 °C).

7. Time and Temperature Requirements for Packaging and Freezer Placement for Ground Turkey.

a. Ground product exiting the size-reduction process with an internal product temperature higher than 40 °F (4.4 °C) must be packaged into casings within 2 hours of size reduction and placed in a freezer within 1 hour of packaging.

## II.C.7.

b. Ground product exiting the size-reduction process and immediately entering a continuous chilling system that continuously lowers and maintains the product at an internal product temperature of not higher than 40 °F (4.4 °C) and not lower than 36 °F (2.2 °C) must be packaged and placed in a freezer within 12 hours of size reduction.

c. Ground product exiting the size-reduction process and immediately entering a continuous chilling system that continuously lowers and maintains the product at an internal product temperature of 36 °F (2.2 °C) or below must be packaged and placed in a freezer within 24 hours of size reduction.

d. Other continuous chilling system(s) may be used when the systems are reviewed and found acceptable by supervisory personnel of the Grading Branch, Poultry Programs.

### 8. Organoleptic Requirements and Defects.

a. Organoleptic requirements. The ground turkey will be examined on a continuous basis for the organoleptic requirements listed in Table 2 below in the fresh state. Any ground turkey that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. Defects. **Only ground turkey that has been produced through a simultaneous size-reduction and bone removal system will be examined for the defects listed in Table 2.**

**When a simultaneous size-reduction and bone removal system has been used,** a 5-pound (2.27 kg) sample of ground turkey will be examined for the defects listed in Table 2 below prior to packaging into casings, forming into turkey burgers, or formulating into turkey sausage. The defect requirements will be examined in the fresh state.

(1) The examination for bone will be made separately from the examination for other defects.

(2) Regardless of the kind and number of defects (within Table 2) found, any sample containing bone and bone-like material will be cause for rejection of the product the sample represents.

(3) The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' SPL-2.

(4) If the sample contains bone or bone-like material, or has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

**Table 2. Organoleptic Requirements and Defects for Ground Turkey**

<b>Organoleptic Requirements:</b>	<p><b>Must have:</b> (1) muscle fibers and a strand-like texture and (2) a uniform light and bright color with no discoloration or dehydration.</p> <p><b>Must not have:</b> (1) the texture of comminuted meat or skin, (2) a gritty texture, or (3) an emulsified or pasty consistency.</p> <p><b>Must be free of:</b> (1) rancidity; (2) sour, stale, fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, acidic, or other off or foreign odors, and (3) foreign materials (e.g., glass, paper, rubber, metal).</p>
<b>Defects:</b>	
<b>Bone:</b>	<b>Must be free of:</b> bone and bone-like material.
<b>Other:</b>	<b>Must be free of:</b> hard tendon or tendinous material, ligament or ligamentous material, or cartilage (gristle) which exceed 0.50 inch (1.27 cm) in any dimension.

9. Packaging and Packing Ground Turkey. All packaging and packing materials must comply with the requirements in section III.

a. Materials.

(1) Ground turkey must be packaged in plastic-film casings which have good oxygen barrier properties and are moisture-proof. Any seams must provide the same protective qualities as the body of the casing.

(2) Other types of packaging materials may be approved by the Deputy Administrator of Poultry Programs, in writing.

b. Packaging. The casings must be filled with 10 pounds (4.54 kg) of ground turkey. Filled casings of ground turkey must be uniform in diameter and in length. The air must be worked out through the open end of the filled casings and the casings sealed by metal or plastic clip in a manner that will protect the commodity from dehydration, freezer burn, or quality deterioration. Metal wire ties, paper-coated wire ties, or staples must not be used for sealing casings.

c. Packing. Four casings (packages) of ground turkey must be packed in each fiberboard shipping container to 40 pounds (18.14 kg) net weight.

10. Ground Turkey Rework.

a. Eligible product. Ground turkey may be reworked provided: (1) the temperature of the ground turkey has not exceeded 50 °F (10 °C) and has been maintained at that temperature or lower, (2) it complies with organoleptic requirements of II.C.8., and (3) it is incorporated into batches of ground turkey, packaged, and placed in a freezer within

12 hours.

## II.C.10.

b. Time and temperature requirements. Additionally, ground turkey which has been chilled to 15 °F (-9.4 °C) or lower, packaged, and maintained at a product temperature of 15 °F (-9.4 °C) or lower may be reworked within 3 days from the end of the shift it was produced. When the chilled ground turkey is reworked, the temperature of the commodity must not exceed 40 °F (4.4 °C) during tempering.

11. Freezing Ground Turkey. Packaged ground turkey must be continuously lowered to an internal temperature of 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of packaged ground turkey does not comply with the freezing requirements, the product or lot the sample represents will be rejected for use under this Specification.

### D. Processing of Ground Turkey Into Turkey Burgers

#### 1. Prerequisites for Use of Ground Turkey.

a. Temperature. The internal product temperature of ground turkey must be not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) before it is processed into turkey burgers and will be determined just before it enters the forming system. No frozen or previously frozen ground turkey may be used. Ground turkey which does not comply with the temperature requirements of this paragraph, and II.C.7.b. or c. (except that the product must not be frozen) will be rejected for use under this Specification.

b. Ground turkey from other plants. Chilled ground turkey may be transferred or obtained from other plants to produce turkey burgers, provided it is: (1) processed, handled, and identified in accordance with this Specification and meets the time and temperature requirements outlined in II.C.7. (except that product must be chilled (not frozen) as detailed in II.D.1.b.(2) below), and (2) processed from turkey products which comply with the freshly slaughtered, nonbasted, organoleptic, and other applicable requirements of this Specification for turkey products as evidenced by USDA certification.

(1) Type, class, specific name of the product, date slaughtered, and the USDA-assigned plant number must be shown on each shipping container of ground turkey.

(2) The chilled ground turkey must be maintained at an internal product temperature not higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C) when shipped from the origin plant and when received at the destination plant.

c. Examination for defects and organoleptic requirements. The ground turkey will be examined for defects and organoleptic requirements before forming into turkey burgers. (See II.C.8.) The frequency of sampling and the number of samples examined will be those outlined in Poultry Programs' SPL-2.

2. Processing Sequence. Unless otherwise specified, forming, chilling, and packaging of turkey burgers must be a continuous process that complies with the time and temperature requirements of this Specification.

3. Forming Into Turkey Burgers.

a. Formed burger diameter (size). The ground turkey must be mechanically formed into 3-ounce (85.05 grams) burgers which are: (1) uniform in thickness, and (2) approximately round in shape. The forming plate must have an approximate diameter of 4.25-4.75 inches (10.80-12.07 cm). Compliance for this requirement will be made by measuring the diameter of the forming plate according to established Poultry Programs' procedures. Verification will be made at the start of each processing shift.

b. Forming equipment.

(1) Water assist. The forming machine may have a "water assist" system (fine spray of water, for example, on the forming plate or head) to improve operational performance and forming function when approved by FSIS.

(2) Cubing. The turkey burgers may have a cube pattern (square shape indentations) or a checkered indentation pattern on one surface (top) of the burgers.

4. Chilling Turkey Burgers. Turkey burgers must be chilled by one of the methods permitted below:

a. Chilling **prior to** packaging. Compliance with temperature requirements of turkey burgers chilled prior to packaging will be determined as burgers exit the chilling system.

(1) After forming, the internal temperature of the individual turkey burgers must be lowered to 15 °F (-9.4 °C) or lower through a chilling system in-line with the forming machine.

(2) As an alternative, the turkey burgers may be chilled using one of the following methods provided the chilling of the turkey burgers starts within 1 hour of forming the turkey burgers.

(a) Chilling the individual turkey burgers to an internal product temperature of 15 °F (-9.4 °C) or lower through a chilling system which is not connected to the forming system or which is located in another area of the plant; e.g., nitrogen tunnel or spiral freezer.



#### **II.D.4.**

(b) Chilling the individual turkey burgers continuously to an internal temperature of 15 ° to 20 °F (-9.4 ° to -6.7 °C) through a chilling system in-line with the forming machine provided the product is packaged, packed, and placed in the freezer within 1 hour of chilling.

(c) Chilling the individual turkey burgers or stacks of turkey burgers on racks in a freezer by procedures approved by FSIS. The internal product temperature of the turkey burgers must be continuously lowered to 15 °F (-9.4 °C) or lower during chilling.

b. Chilling/freezing **after** packaging. As an alternative to chilling turkey burgers before packaging (as previously described in II.D.4.a. above), the turkey burgers can be packaged without chilling when the packaging and freezing procedures comply with the following:

(1) The turkey burgers will be packaged and placed in a freezer within 2 hours of forming and the freezing process started so the internal temperature of the packaged turkey burgers will be continuously lowered to 0 °F (-17.8 °C) or lower within 48 hours from the time of entering the freezer. The temperature of the packaged turkey burgers will not be higher than 40 °F (4.4 °C) when they enter the freezer.

(2) The turkey burgers must be packaged as described in II.D.5.b. in a manner that will prevent the turkey burgers from sticking together.

(3) The packages of turkey burgers will be packed into shipping containers after the turkey burgers are frozen to 0 °F (-17.8 °C) or lower.

c. Other alternatives to chilling turkey burgers prior to and after packaging may be approved by the Deputy Administrator of Poultry Programs, in writing.

5. Packaging and Packing Turkey Burgers. All packaging and packing materials must comply with the requirements in section III.

a. Materials. Turkey burgers must be packaged in plastic-film bags or plastic-film formed pouches. The pouches must be made of heat-sealable plastic-film with excellent to good barrier properties (e.g., oxygen and moisture). A low density polyethylene film bag or pouch with a wall thickness of not less than 3 mil (0.003 inch) may be used. Any seams must provide the same protective qualities as the bag or pouch.

b. Packaging.

(1) The turkey burgers must be stacked in the bag or pouch with one or two sheets of commercial patty paper between each burger. Approximately 6, 9, 12, or 18 pounds (2.72, 4.08, 5.44, or 8.16 kg) of turkey burgers may be stacked in each bag or pouch.

(2) The excess air must be removed (e.g., by suction, pressure, etc.) from each bag or pouch so the air is removed from the void areas, and the bag or pouch clings to or fits snugly against the burgers. The pouches must be formed to fit snugly against the burgers.

(3) After the air is removed, the bags must be: (a) Heat sealed, (b) sealed with a plastic or metal clip, or (c) sealed with a device that provides an equivalent seal. The pouches must be heat sealed. Metal wire ties, paper-coated wire ties, or staples must not be used for sealing bags or pouches.

c. Packing. The packages of turkey burgers must be packed in fiberboard shipping containers with 36 pounds (16.33 kg) net weight of turkey burgers in each shipping container.

d. Other packaging materials and sizes. Other types of packaging materials or sizes of packages may be approved by the Deputy Administrator of Poultry Programs, in writing.

6. Formed Burger Weight. After packaging, a sample of 10 formed turkey burgers will be used to determine the weight.

a. The 10 turkey burgers in a sample must average not less than 3.00 ounces (85.05 g) each. An individual turkey burger in a sample must not weigh less than 2.70 ounces (76.54 g) or more than 3.30 ounces (93.56 g).

b. The frequency of sampling will be according to Poultry Programs' SPL-2. If any sample does not comply with the weight requirements, the turkey burgers the sample represents will be rejected.

7. Condition of Turkey Burgers.

a. The packaged turkey burgers will be sampled and examined for the presence of: (1) misshaped, smashed, and fractured (separated into two or more separate pieces) turkey burgers, and (2) turkey burgers or stacks of turkey burgers which are stuck together.

b. The turkey burgers may be examined in the chilled state or in the frozen state. The samples for examination in the chilled state will be drawn after the chilled turkey burgers are packaged. The samples for examination in the frozen state will be drawn from the packages after freezing.

c. The frequency of sampling, the number of samples examined, and the number of defects allowed in the chilled state or frozen state (after freezing) will be those outlined in Poultry Programs' SPL-2.

## **II.D.**

### **8. Reprocessing of Turkey Burgers.**

a. Eligible product. Turkey burgers which are misshaped, fractured (separated into two or more pieces), or do not meet the size and weight requirements may be reprocessed provided: (1) The temperature of the turkey burgers has not exceeded 50 °F (10 °C) and they have been maintained at that temperature or lower, (2) they comply with the ground turkey organoleptic requirements of II.C.8., and (3) they are reprocessed into turkey burgers, packaged, and placed in a freezer within the 12 hours.

b. Time and temperature requirements. In addition, turkey burgers which have been chilled to 15 °F (-9.4 °C) or lower, packaged, and maintained at a product temperature of 15 °F (-9.4 °C) or lower may be reprocessed within 3 days from the end of the shift they were produced. When the chilled turkey burgers are reprocessed, the temperature of the turkey burgers must not exceed 40 °F (4.4 °C) during tempering.

9. Freezing Turkey Burgers. Except as provided in this Specification, the packaged and packed turkey burgers must be placed in a freezer within 4 hours of chilling and packaging. The internal temperature of the packaged and packed turkey burgers must be continuously lowered to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of turkey burgers does not comply with the freezing requirements, the product or lot the samples represent will be rejected for use under this Specification.

### **E. Processing of Ground Turkey Into Turkey Sausage**

#### **1. Prerequisites for Use of Ground Turkey.**

a. Temperature. No frozen or previously frozen ground turkey may be used. Ground turkey which does not comply with the temperature requirements of this paragraph, and II.C.7.a., b. or c. (except that the product must not be frozen) will be rejected for use under this Specification.

b. Ground turkey from other plants. Chilled ground turkey may be transferred or obtained from other plants to produce turkey sausage, provided the ground turkey is: (1) processed, handled, and identified in accordance with this Specification and meets the time and temperature requirements outlined in II.C.7. (except that product must be chilled (not frozen) as detailed in II.E.1.b.(2) below), and (2) processed from turkey products which comply with the freshly slaughtered, nonbasted, organoleptic, and other applicable requirements of this Specification for turkey products as evidenced by USDA certification.

(1) Type, class, specific name of the product, date slaughtered, and the USDA-assigned plant number must be shown on each shipping container of ground turkey.

## II.E.1.

(2) The chilled ground turkey must be maintained at an internal product temperature not higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C) when shipped from the origin plant and when received at the destination plant.

c. Examination for defects and organoleptic requirements. The ground turkey will be examined for defects and organoleptic requirements prior to formulating into turkey sausage. (See II.C.8.) The frequency of sampling and the number of samples examined will be those outlined in Poultry Programs' SPL-2.

2. Processing Sequence. Unless otherwise specified, ground product formulation, turkey sausage formulation, mixing, forming/stuffing, chilling, packaging/packing, and freezing of the commodity must be a continuous process that complies with the time and temperature requirements of this Specification.

3. Formulation. Ground turkey sausage must be prepared from the following formula:

	<u>Percentage</u>
Ground Turkey	91.60
Water	5.50
Salt - noniodized	1.40
Spices and Flavorings	0.80
Spices - must equal 0.60 percent:	
Sage - 0.30 percent	
Ginger - 0.15 percent	
White Pepper - 0.10 percent	
Red Pepper - 0.05 percent	
Flavorings - must equal 0.20 percent:	
Spice Extractives - 0.10 percent	
Rosemary Extractives 0.10 percent	
Brown Sugar	0.50
Dextrose	<u>0.20</u>
Total	100.00

a. Spices and flavorings must be the types used in conjunction with mild sausage flavoring. The contractor must furnish the USDA grader a statement by the manufacturer certifying the spice and flavoring amounts for compliance with this formulation requirement prior to production.

b. Sugar must be brown sugar and dextrose. The name or type sugar used must appear in the ingredients statement (e.g., brown sugar and dextrose).

c. Kind and amount of salt, brown sugar, dextrose, spices, and flavorings used to produce turkey sausage are limited to the amounts specified in this Specification.

## **II.E.**

d. Only the ingredients listed in the formulation (II.E.3.) above may be used, no binders or extenders are allowed. Processing aids (e.g., anti-caking agents, anti-dusting agents, or other manufacturing aids) are allowed if used and labeled in accordance with FSIS requirements. If processing agents are used, the ingredients and amount of ingredients listed in the formulation (II.E.3.) must remain the same.

e. The dry ingredients may be mixed with the water and added as a solution to the meat during mechanical mixing.

f. The contractor/processor may elect to formulate the commodity without water. If this option is selected, the percentage of ground turkey used must increase to 97.10 percent. Other ingredient percentages must remain the same. Spices, flavorings, and other dry ingredients must be: (1) thoroughly mixed with ground turkey as detailed in II.E.4. below, and (2) listed in proper name and order in accordance with 9 C.F.R. § 381.118.

4. Mixing. A uniform blend of salt, sugars, spices and flavorings, and ground turkey must be achieved by mechanically mixing all ingredients.

5. Temperature. The temperature of the formulated and blended turkey sausage mixture must be lowered to an internal temperature of 40 °F (4.4 °C) or lower before it is stuffed into casings. CO<sub>2</sub> or N<sub>2</sub> may be used before, during, or after mixing to comply with this requirement. Ice or ice water must not be used to lower the temperature of the formulated turkey sausage.

6. Packaging and Packing Turkey Sausage. All packaging and packing materials must comply with the requirements in section III.

a. Materials.

(1) Turkey sausage must be packaged in plastic-film casings which have good oxygen barrier properties and are moisture-proof. Any seams must provide the same protective qualities as the body of the casing.

(2) Other types of packaging materials may be approved by the Deputy Administrator of Poultry Programs, in writing.

b. Packaging. The formulated and blended turkey sausage mixture must be packaged into plastic-film casings. The casings must be filled with approximately 3 or 5 pounds (1.36 or 2.27 kg) of turkey sausage. Filled casings of turkey sausage must be uniform in diameter and in length.

## II.E.6.

(1) The air must be worked out through the open end of the filled casings and the casings sealed by metal or plastic clip in a manner that will protect the commodity from dehydration, freezer burn, or quality deterioration.

(2) Metal wire ties, paper-coated wire ties, or staples must not be used for sealing casings.

(3) Other package sizes may be approved by the Deputy Administrator of Poultry Programs, in writing.

c. Packing. Ten 3-pound (1.36 kg) or six 5-pound (2.27 kg) casings (packages) of turkey sausage must be packed in each fiberboard shipping container to 30 pounds (13.61 kg) net weight.

### 7. Reprocessing of Turkey Sausage.

a. Eligible product. Casings of turkey sausage which do not meet the weight requirements or are damaged or misshaped may be reprocessed provided the: (a) temperature of the turkey sausage has not exceeded 50 °F (10 °C) and has been maintained at that temperature or lower; (b) inedible plastic casings are removed; and (c) turkey sausage is reprocessed into turkey sausage, packaged, and placed in a freezer within the 12 hours.

b. Time and temperature requirements. Additionally, turkey sausage which has been chilled to 15 °F (-9.4 °C) or lower, packaged, and maintained at a product temperature of 15 °F (-9.4 °C) or lower may be reprocessed within 3 days from the end of the shift they were produced. When the chilled turkey sausage is reprocessed, the temperature of the commodity must not exceed 40 °F (4.4 °C) during tempering.

8. Freezing Turkey Sausage. Except as provided in this Specification, the packaged and packed commodity must be placed in a freezer within 4 hours of chilling and packaging. The internal temperature of the packaged and packed commodity must be continuously lowered to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of the commodity does not comply with the freezing requirements, the product or lot the samples represent will not be accepted for use under this Specification.

## F. Metal Detection for Ground Turkey, Turkey Burgers, and Turkey Sausage

### 1. Requirements.

a. The commodity must be examined by a metal detection device: (1) accepted by FSIS; and (2) capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire.

## **II.F.1.**

b. The commodity must be presented correctly within the detection field pattern of the device. Procedures used must be appropriate for the dimensions, location, and pattern of the detection field, the “orientation effect” on the sensitivity of the device, the environmental conditions, and the commodity.

2. Operating Efficiency and Procedures. The operating efficiency of the metal detection device will be determined hourly by a USDA grader by placing a detection test strip with a sphere of 440 stainless steel in the center of the detection field pattern. Poultry Programs will provide the detection test strips with the stainless steel sphere of the specified diameter.

a. Ground turkey and turkey sausage.

(1) Ground turkey and turkey sausage must be examined in individual packages, by an in-line detection installed in the mechanical stuffing system, or after it is packed in shipping containers.

(2) The USDA grader will use a detection test strip with a 3.00 mm (0.1181 inch) sphere for the examination of ground turkey and turkey sausage in: (a) a package, (b) a shipping container, or (c) an in-line system, as applicable for the detection system.

(3) As an alternate test method for an in-line detection device, a 1.50 mm (0.0591 inch) sphere may be placed in the detection field outside and adjacent to the device carrying the ground turkey or turkey sausage.

b. Turkey burgers.

(1) Turkey burgers must be examined one layer thick prior to packaging or after they are: (a) stacked, (b) packaged, or (c) packed in shipping containers.

(2) The USDA grader will use a detection test strip with a 1.50 mm (0.0591 inch) sphere for turkey burgers examined one layer thick, or stacked, and a 3.00 mm (0.1181 inch) sphere for those examined in a package or in a shipping container.

3. Contaminated Product. These guidelines do not relieve the contractor of the responsibility to provide a safe product. Commodity suspected of being contaminated with metal, or found to be contaminated with metal, will be handled in accordance with FSIS procedures.

4. Other Detection Procedures. Other procedures for examination of the commodity may be approved by the Deputy Administrator of Poultry Programs, in writing.

G. Fat Requirements for Packaged Commodity1. Fat Content.

a. Ground turkey and turkey burgers. A lot or subplot (as defined in II.H.1. and II.H.2.) of packaged ground turkey or turkey burgers must contain no more than an average of 11.0 percent fat.

b. Turkey sausage. A lot or subplot (as defined in II.H.1. and II.H.2.) of packaged turkey sausage must contain no more than an average of 13.0 percent fat.

2. Price Discounts for Ground Turkey and Turkey Burgers.

a. A lot or subplot of packaged ground turkey or turkey burgers with more than 11.0 percent fat (average for the lot or subplot) but not more than 12.5 percent fat will be accepted with the following deviations subject to the price discount indicated:

<u>Fat Content (Average for Lot)</u> <u>USDA Laboratory Analysis</u>	<u>Discount Applicable</u>
Greater than 11.0% but not more than 11.5%	2.5% of contract price
Greater than 11.5% but not more than 12.0%	5.0% of contract price
Greater than 12.0% but not more than 12.5%	7.5% of contract price

b. A lot or subplot of packaged ground turkey or turkey burgers with more than 12.5 percent fat (average for the lot or subplot) will be rejected. A lot or subplot will be rejected when the results of the average of any one of the composite samples exceed 13.0 percent fat.

3. Price Discounts for Turkey Sausage.

a. A lot or subplot of packaged turkey sausage with more than 13.0 percent fat (average for lot or subplot), but not more than 14.5 percent fat will be accepted with the following deviations subject to the price discount indicated:

<u>Fat Content, Basis</u> <u>USDA Laboratory Analysis</u>	<u>Applicable Discount</u>
Greater than 13.0% but not more than 13.5%	2.50% of contract price
Greater than 13.5% but not more than 14.0%	5.00% of contract price
Greater than 14.0% but not more than 14.5%	7.50% of contract price

b. A lot or subplot of packaged turkey sausage with more than 14.5 percent fat (average for the lot or subplot) will be rejected. A lot or subplot will be rejected when the results of the average of any one of the composite samples exceed 15.0 percent fat.



## II.

### H. Lots and Sublots

#### 1. Definition of a Lot.

a. A lot is the amount of packaged commodity produced during a processing shift.

b. The packaged commodity will be: (1) sampled for laboratory analyses and analyzed for compliance with fat content requirements, and (2) accepted, rejected, or accepted subject to a price discount, on a lot basis.

#### 2. Definition of a Sublot.

a. A lot may be separated into sublots for the purpose of sampling and analyzing for compliance with the fat content requirements. If this option is used, the packaged commodity must be sublotted on the basis of consecutively produced: (1) shipping containers or (2) pallets. The sublots of containers or pallets must be consecutively identified at the time of packaging or packing.

b. Commodity sampled and analyzed on the basis of sublots will be accepted, rejected, or accepted with a discount on a sublot basis for fat content.

### I. Sampling and Laboratory Analyses

#### 1. Sampling.

a. A lot. The number of packages of ground turkey and turkey sausage (fresh state), or turkey burgers (chilled or frozen state) to be drawn from each lot will be as follows:

<u>Number of Shipping Containers in Lot</u>	<u>Number of Packages</u>
250 or less	8
251 - 500	12
501 - 1,000	16
1,001 - 2,000	24
Over 2,000	36

b. A sublot. A minimum of four (4) packages will be drawn from each sublot. The total number of packages drawn from each sublot must be a multiple of four. The total number of packages drawn from all sublots in a lot must equal or exceed those specified for the appropriate size lot described in paragraph a. above.

c. After packaging, the USDA grader will draw random samples for fat content analysis.

2. Samples for Laboratory Analyses.

a. The USDA grader will randomly draw filled casings of ground turkey and turkey sausage (fresh state), or packages of turkey burgers (chilled or frozen state) from each lot or subplot and prepare samples as follows:

(1) Ground turkey. A 1-inch (2.54 cm) cross-section will be randomly removed from each filled casing of ground turkey selected. Each cross-section will be divided into three equal pieces.

(2) Turkey burgers. The USDA grader will draw three turkey burgers at random from each package of chilled or frozen turkey burgers.

(3) Turkey sausage. A 2-inch (5.08 cm) cross-section will be randomly removed from each filled casing of turkey sausage selected. Each cross-section will be divided into three equal pieces.

b. Each portion or sample will be placed in a separate moisture-proof sample bag.

c. The three portions of each cross-section or sample will be used as follows:

--one for fat analysis at a USDA laboratory.

--one for the contractor.

--one for a reserve sample.

d. Samples will be kept in a freezer under the USDA grader's control until all samples are drawn and prepared for the lot or subplot.

(1) The reserve samples will be retained in a freezer under the control of the USDA grader. Reserve samples will be used for laboratory analyses when: (a) the original samples are lost; (b) the original samples arrive at the USDA laboratory in a condition that does not permit accurate analyses; or (c) requested by the Grading Branch, Poultry Programs, Washington, D.C.

(2) The samples for the contractor will be given to the contractor after the lot or subplot has been produced and all the samples for the lot or subplot have been drawn and prepared.

e. Samples which are not used by USDA will be returned to the contractor and reworked in accordance with II.C.10. for ground turkey, II.D.8. for turkey burgers, and II.E.7 for turkey sausage.

## II.I.

### 3. Laboratory Analyses.

a. The USDA laboratory will equally combine the samples submitted for a lot or subplot in numerical sequence into four composite samples.

b. The USDA laboratory will grind and mix each composite sample twice into a homogeneous mixture.

c. Each composite will be analyzed in duplicate for fat. The USDA laboratory will report the result for each duplicate to the nearest 100th of a percent and the average for each composite to the nearest 10th of a percent on the USDA certificate. In addition, the USDA laboratory will average the results of the composites and report the average for the lot or subplot to the nearest 10th of a percent on the USDA certificate, except when the average result for any one composite sample exceeds 13.0 percent fat for ground turkey, 13.0 percent fat for turkey burgers, and 15.0 percent fat for turkey sausage.

d. Chemical analyses will be in accordance with the following methods found in the "Official Methods of Analysis," of the Association of Official Analytical Chemists International (AOAC International), Sixteenth Edition, 1995, Chapter 39: "Meat and Meat Products," Subchapter 1, Sections 39.1.05, 39.1.06, and 39.1.07.

<u>Finished Product</u>	<u>Test Method</u>
Fat	Petroleum ether method or Rapid microwave-solvent extraction method

4. USDA Laboratories. The samples for laboratory analyses may be submitted to any one of the USDA laboratories listed below, except when AMS determines that conditions or workload of a specific laboratory does not permit the prompt handling of samples. All costs incurred for shipping the samples and the laboratory analyses will be paid by the contractor.

USDA, AMS, Science and Technology Programs  
Eastern Laboratory  
645 Cox Road  
Gastonia, North Carolina 28054  
Telephone (704) 867-1882

USDA, AMS, Science and Technology Programs  
Midwestern Laboratory  
3570 North Avondale Avenue  
Chicago, Illinois 60618  
Telephone (312) 353-6525

Laboratory Services Division  
Minnesota State Department of Agriculture  
90 West Plato Boulevard  
St. Paul, Minnesota 55107  
Telephone (612) 296-3273

Laboratory Services Division  
Oregon Department of Agriculture  
200 Hawthorn Street, South East, Suite A140  
Salem, Oregon 97310-0110  
Telephone (503) 986-4565

5. Timely Receipt of Laboratory Results. The contractor must present the commodity to USDA so the product may be sampled, the samples sent to the USDA laboratory, and the laboratory analyses performed in time for the laboratory results to be available for the

contractor to meet the shipment or delivery requirements of the contract. If laboratory results are received by the contractor later than 7 calendar days, excluding Sundays and Federal Holidays, from the receipt of the samples by the USDA laboratory, the number of days' delay will be added to the shipment or delivery period before liquidated damages for late shipment or delivery will be assessed.

6. Appeal of Laboratory Analyses. An appeal of original laboratory analyses for a lot or subplot may be authorized by the Grading Branch, Poultry Programs, Washington, D.C. The appeal must be filed and made in accordance with the provisions for an appeal in 7 C.F.R. Part 70. Only one appeal per lot or subplot is permitted.

a. For the appeal, a lot or subplot will be sampled and samples prepared by one of the following procedures:

(1) When the reserve samples are available, the USDA grader will randomly draw from the lot or subplot the same number of samples as drawn during original sampling and prepare the samples as outlined in paragraphs II.I.1. and II.I.2. These samples, plus the reserve samples previously prepared during the original sampling of the lot, or subplot, will be submitted for fat analyses.

(2) When the reserve samples are not available, the USDA grader will randomly draw twice the number of samples required in paragraph II.I.1. from the lot or subplot. Samples will be prepared as outlined in paragraph II.I.2. and submitted for fat analysis.

b. The samples for the appeal will be submitted to the USDA laboratory where the original fat analyses were performed.

c. The USDA laboratory will combine the samples into twice the number of composites described in paragraph II.I.3.c. and analyze each of the composite samples for fat content. The results will be reported as outlined in paragraph II.I.3.c.

d. The laboratory results of the samples for the appeal will supersede those of the original analyses and will be final.

7. Replacement of Commodity Sampled. The contractor will replace the packages of commodity which were sampled.

#### J. Contractor Analysis of Fat Content Program

As an alternative method of sampling and laboratory analyses detailed in section II.I., the contractor may elect to participate in the Contractor Analysis of Fat Content (CAFC) program dated May 1996. AMS has developed this program to permit the use of contractor results to determine compliance with fat content requirements. Any questions about this program should be referred to the Contracting Officer at the following address:

## II.J.

Contracting Officer, Commodity Procurement Branch  
Poultry Programs, AMS, Rm. 3941-S  
U.S. Department of Agriculture  
P.O. Box 96456  
Washington, D.C. 20090-6456  
Telephone: (202)720-7693  
Fax: (202)720-5871

The Contracting Officer will provide the procedures for participation in the CAFC program. The contractor must comply with the: (a) requirements in this Specification (excluding section II.I.), and (b) alternate sampling procedures, lab analyses, and other provisions of the CAFC Program.

## III. PACKAGING AND PACKING MATERIALS

### A. Material Requirements

1. Requirements. All packaging and packing materials must be new and clean, and must not impart objectionable odors or flavors to the commodity.

2. Casings or Plastic-film Bags or Pouches.

a. The casings or plastic-film bags or pouches, and the patty paper must be safe (not adulterated or injurious to health) for use in contact with food products. The safety of food-contact packaging materials will be determined by FSIS according to the criteria and procedures in 9 C.F.R. § 381.144.

b. The casings or plastic-film bags or pouches must have: (a) low-temperature flexibility (not brittle) and durability to resist stress-cracking caused by the temperatures of freezing and frozen storage, and (b) the impact strength, tensile strength, and tear resistance to protect the commodity from contamination, dehydration, freezer burn, or quality deterioration during the conditions of use.

### B. Shipping Containers

1. Requirements. Shipping containers must: (a) be a fiberboard container; (b) be of such size to pack the commodity without slack filling or bulging; (c) protect the commodity against loss and damage; (d) withstand the variations in humidity and temperature during the conditions of use; and (e) have the combined facings weight, the bursting strength, and the compression strength (edge crush value) to withstand the stresses of handling, shipping, stacking, and storage.

2. Container Bottom. Flaps on the bottom of a shipping container must be securely fastened so the bottom remains securely fastened when the top of the container is opened.

### III.B.

3. Final Closure. Final closure of the fiberboard shipping containers must be secure and made with commercially acceptable filament-reinforced tape, plastic film packaging tape, non-metallic strapping, adhesive, or other similar types of materials that can be used for cold temperature storage conditions and that provide for safe handling of the commodity. Steel or wire straps must not be used for the final closure. Staples must not be used for the final closing of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. However, staples may be used to manufacture and to assemble the shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

## IV. LABELING

### A. Requirements

1. Printing Requirement. Printed, stamped, and stenciled labeling and marking information on shipping containers and packaging materials must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

2. Labeling Format. Any deviation from labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to the start of production.

### B. Packaged Commodity

1. Requirements. Date of production (month, day, and year) must be shown on each casing, bag, and pouch. The USDA-assigned plant number must appear on each sealing device, or legibly printed on each casing, bag, or pouch. The name and address of the contractor or processor must not appear on the sealing device, casing, bag, or pouch.

### 2. Preprinted Casings, Bags, and Pouches.

a. With the exception of the requirements in IV.B.1. above, no additional labeling of the packaging materials is required.

b. However, preprinted casings, bags, or pouches may be used if the name of the commodity is the same as on the shipping containers and any commodity, nutrition facts information or panel, qualifying statement, or fat content statement on the casings, bags, or pouches does not conflict with the requirements of this Specification. If preprinted casings, bags, or pouches are used, the FSIS Safe Handling Instructions must be preprinted or applied as a separate pressure-sensitive label on each casing, bag, or pouch in accordance with 9 C.F.R. § 381.125.

## IV.

### C. Shipping Containers

1. Labeling Provisions. Labeling and marking of the commodity must be in accordance with this Specification. Labeling is subject to the provisions of 9 C.F.R. § 381.132(c)(3)(iv). The name and address of the contractor or processor must not appear on the shipping containers.

2. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 1. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

### 3. Universal Product Bar Code.

a. A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., 8163 Old Yankee Road, Suite J, Dayton, Ohio 45458.

b. The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodities purchased under this Specification. The contractors need not join Uniform Code Council, Inc.

(1) Ground turkey. The 14-digit UPC code for shipping containers of ground turkey is: 1 07 15001 01540 9

(2) Turkey burgers. The 14-digit UPC code for shipping containers of turkey burgers is: 1 07 15001 01541 6

(3) Turkey sausage. The 14-digit UPC code for shipping containers of frozen turkey sausage is: 1 07 15001 01542 3

c. The UPC code must be placed in the lower right-hand corner of both side panels of the shipping containers.

### 4. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be preprinted, stamped, or stenciled, on shipping containers. This information, in essentially the same layout, is provided in EXHIBIT 2, "Label Information For Shipping Containers Of Frozen Ground Turkey;" EXHIBIT 3, "Label Information For Shipping Containers Of Frozen Turkey

Burgers;" and EXHIBIT 4, "Label Information For Shipping Containers Of Frozen Turkey Sausage."

b. "END" and "SIDE" designations. For the purpose of labeling and marking, the "end" and "side" panels may relate to the shortest and longest dimensions of the shipping container at the discretion of the contractor/processor. However, the panels must alternate between "end" panel and "side" panel designation with the two side panels and two end panels being located on opposite panels of the shipping container.

5. Safe Handling Instructions. FSIS Safe Handling Instructions must be preprinted or applied as a separate pressure-sensitive label on each shipping container. The label must be in accordance with 9 C.F.R. § 381.125 and not cover the labeling information required within this Specification.

6. TOP PANEL - Labeling and Marking. The following information must appear on the top panel of each shipping container:

a. Type, name, and ingredients statement (for turkey sausage).

(1) For ground turkey:

FROZEN GROUND TURKEY

(2) For turkey burgers:

FROZEN TURKEY BURGERS

(3) For turkey sausage, the ingredients statement must be printed on the top panel and on the "one side" designated panel of the shipping container following the commodity type and name. Ingredients must be listed in proper name and order in accordance with 9 C.F.R. § 381.118.

FROZEN TURKEY SAUSAGE

Ingredients:

(4) Commodity produced with addition of skin, in amounts exceeding that of natural proportion, must be identified on the label (see section II.C.2. and 9 C.F.R. § 381.117). In addition to the other required information, the commodity name must be labeled on the top panel of the shipping container as follows:

(a) For ground turkey:

FROZEN GROUND TURKEY with SKIN ADDED



#### IV.C.6.

(b) For turkey burgers:

FROZEN TURKEY BURGERS with SKIN ADDED

(c) For turkey sausage:

FROZEN TURKEY SAUSAGE with SKIN ADDED

Ingredients:

b. Storing instructions. The following storing instructions must be printed on the top panel of the shipping container:

PERISHABLE--KEEP FROZEN  
KEEP AT ZERO DEGREE F (-17.8 °C) OR BELOW

c. Key points for handling commodities. Handling information is required on each shipping container for the applicable commodity. The “KEY POINTS FOR HANDLING” must be legibly printed on the top panel of each shipping container. This information, in essentially the same layout, is set out in EXHIBITS 2, 3, and 4.

d. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on each shipping container. This nutritional facts information or “nutrition facts panel” must be in compliance with the FSIS nutritional labeling requirements found in 9 C.F.R. § 381.400(b) through § 381.499.

(1) The contractor/processor must select one of the following methods of providing the nutrition facts panel:

(a) Preprinted on the top panel of each shipping container; or

(b) Printed on a pressure-sensitive label and applied to the top panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

(2) NOTE: The nutrition facts information and panel must be pre-approved by FSIS prior to shipment of the commodity. The method of providing and location of this information for each shipping container (preprinted or pressure-sensitive label) must be indicated on the FSIS label application. The pre-approved nutrition information must be provided to the USDA inspection personnel at the plant where the commodity is to be packed for shipment.

7. ONE END Panel - Labeling and Marking. The following information must appear on one end of each shipping container:

a. Commodity name.

(1) For ground turkey, the following must be printed in letters at least 1 inch (2.54 cm) high:

GROUND TURKEY

(2) For turkey burgers, the following must be printed in letters at least 1 inch (2.54 cm) high:

TURKEY BURGERS

(3) For turkey sausage, the following must be printed in letters at least 1 inch (2.54 cm) high:

TURKEY SAUSAGE

(4) Commodity with additional skin added in amounts exceeding that of natural proportion must be labeled as follows:

(a) For ground turkey with skin added, the following is required and the words "GROUND TURKEY" must be printed in letters at least 1 inch (2.54 cm) high:

GROUND TURKEY with SKIN ADDED

(b) For turkey burgers with skin added, the following is required and the words "TURKEY BURGERS" must be printed in letters at least 1 inch (2.54 cm) high:

TURKEY BURGERS with SKIN ADDED

(c) For turkey sausage with skin added, the following is required and the words "TURKEY SAUSAGE" must be printed in letters at least 1 inch (2.54 cm) high:

TURKEY SAUSAGE with SKIN ADDED

b. Contract number and pack date. The following information may be preprinted, stamped, or stenciled on the shipping container, or on a separate pressure-sensitive label:

(1) Last five digits of the contract number as it appears in the acceptance wire.

(2) Date packed (month, day, and year).

#### IV.C.7.

c. Inspection mark and plant number. The USDA inspection mark and USDA-assigned plant number must be printed on the “one end” designation panel of each shipping container.

d. Net weight. The applicable net weight statement must be printed on the “one end” designated panel of the shipping container.

(1) For ground turkey:

4 Packages Net Combined Weight 40 LBS. (18.14 KG)

(2) For turkey burgers, the following net weight statement must be completed and printed on each shipping container:

\_\_\_ Bags Net Combined Weight 36 LBS. (16.33 KG)

(3) For turkey sausage, the following net weight statement must be completed and printed on each shipping container:

\_\_\_ Bags Net Combined Weight 30 LBS. (13.61 KG)

e. Storing instructions. The following storing instructions must be printed on the “one end” designated panel of each shipping container:

KEEP FROZEN

8. ONE SIDE Panel - Labeling and Marking. The following information must be printed **on the side panel immediately to the right of the “one end” panel** containing the information designated in IV.C.7.

a. Type, name, legend, and ingredients statement (for turkey sausage).

(1) For ground turkey:

FROZEN GROUND TURKEY

Distributed by USDA in cooperation with State and local  
or tribal governments for domestic food assistance programs.  
Not To Be Sold Or Exchanged.

- (2) For turkey burgers:

**FROZEN TURKEY BURGERS**

Distributed by USDA in cooperation with State and local  
or tribal governments for domestic food assistance programs.  
Not To Be Sold Or Exchanged.

- (3) For turkey sausage:

**FROZEN TURKEY SAUSAGE**

**Ingredients:**

Distributed by USDA in cooperation with State and local  
or tribal governments for domestic food assistance programs.  
Not To Be Sold Or Exchanged.

- (2) Commodity with additional skin added in amounts exceeding that of  
natural proportion must be labeled (commodity name) as follows:

- (a) For ground turkey with skin added:

**FROZEN GROUND TURKEY with SKIN ADDED**

Distributed by USDA in cooperation with State and local  
or tribal governments for domestic food assistance programs.  
Not To Be Sold Or Exchanged.

- (b) For turkey burgers with skin added:

**FROZEN TURKEY BURGERS with SKIN ADDED**

Distributed by USDA in cooperation with State and local  
or tribal governments for domestic food assistance programs.  
Not To Be Sold Or Exchanged.

- (c) For turkey sausage with skin added:

**FROZEN TURKEY SAUSAGE with SKIN ADDED**

**Ingredients:**

Distributed by USDA in cooperation with State and local  
or tribal governments for domestic food assistance programs.  
Not To Be Sold Or Exchanged.

- b. USDA symbol. The USDA symbol, copy on back of Specification, is to be a  
minimum of 2.25 inches (5.72 cm) in height, and must be printed on each shipping container.

#### IV.C.8.

c. UPC code. The applicable UPC code (see IV.C.3.) must be printed in the lower right-hand corner of both side panels of each shipping container.

9. THE OTHER END Panel - Labeling and Marking. For each shipping container, the following information must appear on the end opposite the panel designated “one end:”

a. Name of commodity. The commodity name (see IV.C.7.a.) must be printed on each shipping container.

b. USDA symbol. The USDA symbol (see IV.C.8.b.) must be printed on the end opposite the panel designated “one end.”

10. THE OTHER SIDE Panel - Labeling and Marking. For each shipping container, the following information must appear on the side opposite the panel designated “one side:”

a. Type, name, and legend. The commodity type and name, and legend (see IV.C.8.a.) must be printed on the side opposite the panel designated “one side.” **The ingredients statement is not required on this side of shipping containers of turkey sausage.**

b. UPC code. The applicable UPC code (see IV.C.3.) must be printed on the lower right-hand corner of both side panels of each shipping container.

11. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not: (a) contain the contractor or processor name or address, or (b) cover or conflict with the labeling requirements of this Specification.

#### D. Use of Previously Printed Material

Carryover inventories of existing supplies of printed packaging and packing materials from the Commodity Specification for Ground Turkey, Turkey Burgers, and Turkey Sausage dated August 1998 may be used. If the ingredients statement changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.

Shipping containers and labels with incorrect: (1) contract number, (2) plant number, (3) net weight, (4) date packed, (5) ingredients statement, or (6) nutrition facts information or panel must be corrected before they are used. The incorrect information must be blocked out and the correct information legibly printed, stenciled, or stamped in permanent ink.

E. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

## V. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Material and Net Weight Compliance1. Verification of Materials and Defects.

a. Verification of packaging and packing materials. Contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the USDA grader the following certification on company stationery signed by a person authorized to do so by the contractor:

“(I) (We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of the Commodity Specification for Ground Turkey, Turkey Burgers, and Turkey Sausage dated July 1999, comply or will comply with the terms of this Commodity Specification.

Name \_\_\_\_\_

Title \_\_\_\_\_”

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed or closed packages. The exterior of filled casings, bags, or pouches must be clean and free of product.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs' sampling plan, the delivery unit will be rejected.

## **V.A.**

### **2. Net Weight.**

a. A purchase unit or delivery unit must total 40,000 pounds (18,144 kg) net, 36,000 pounds (16,329 kg) net, and 39,000 pounds (17,690 kg) net, or multiples thereof; for ground turkey, turkey burgers, and turkey sausage, respectively.

b. Each delivery unit, except as provided in V.A.2.g., will be examined for compliance with the net weight requirements at time of checkloading

c. The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.

d. Twelve (12) shipping containers for ground turkey and turkey burgers, and 15 shipping containers for turkey sausage will be randomly selected from a delivery unit to determine net weight. The total net weight of the 12 and 15 shipping containers must comply with the following:

#### **(1) Ground turkey.**

(a) For ground turkey, the total net weight of the 12 shipping containers must be equal to or greater than 480 pounds (217.72 kg).

(b) If the total net weight of the sample is less than 480 pounds (217.72 kg), but greater than or equal to 475.20 pounds (215.55 kg), the delivery unit will be accepted at a discount as stated in V.A.2.e. below.

(c) If the total net weight is less than 475.20 pounds (215.55 kg), the delivery unit will be rejected (see V.A.2.f. below).

#### **(2) Turkey burgers.**

(a) For turkey burgers, the total net weight of the 12 shipping containers must be equal to or greater than 432 pounds (195.95 kg).

(b) If the total net weight of the sample is less than 432 pounds (195.95 kg), but greater than or equal to 427.68 pounds (193.99 kg), the delivery unit will be accepted at a discount as stated in V.A.2.e. below.

(c) If the total net weight is less than 427.68 pounds (193.99 kg), the delivery unit will be rejected (see V.A.2.f. below).

(3) Turkey sausage.

(a) For turkey sausage, the total net weight of the 15 shipping containers must be equal to or greater than 450 pounds (204.12 kg).

(b) If the total net weight is less than 450 pounds (204.12 kg), but greater than or equal to 445.50 pounds (202.08 kg), the delivery unit will be accepted at a discount as stated in V.A.2.e. below.

(c) If the total net weight is less than 445.50 pounds (202.08 kg), the delivery unit will be rejected (see V.A.2.f. below).

e. A delivery unit with the average net weight per container listed below will be accepted at the corresponding discount:

(Average Test Net Weight Per Container)

	: But Not	: Contract
<u>Less Than</u>	: <u>Less Than</u>	: <u>Price Discount</u>

Ground Turkey

40.0 pounds (18.14 kg)	: 39.6 pounds (17.96 kg)	: 1.0%
39.6 pounds (17.92 kg)	: --	: Unacceptable

Turkey Burgers

36.00 pounds (16.34 kg)	: 35.64 pounds (16.17 kg)	: 1.0%
35.64 pounds (16.17 kg)	: --	: Unacceptable

Turkey Sausage

30.0 pounds (13.61 kg)	: 29.7 pounds (13.47 kg)	: 1.0%
29.7 pounds (13.47 kg)	: --	: Unacceptable

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Payments will be made on the actual quantity delivered. All price adjustments will be based on a delivery unit.

f. Rejected delivery units may be reworked and reoffered one time only. However, if an individual shipping container in the sample of the reworked delivery unit has a net weight of less than 39.60 pounds (17.96 kg) for ground turkey, 35.64 pounds (16.17 kg) for turkey burgers, or 29.70 pounds (13.47 kg) for turkey sausage, the delivery unit will be rejected.



## V.A.2.

g. As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor, Grading Branch, Poultry Programs will determine that the facilities and procedures are in accordance with applicable Poultry Programs' instructions for this Specification.

### B. Prerequisites for Loading and Shipping Frozen Commodity

1. Visual Inspection. Frozen commodity showing any evidence of defrosting, refreezing, or freezer deterioration will be rejected for use under this Specification.

#### 2. Internal Product Temperature.

a. Requirements. The internal product temperature of frozen commodity must be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) will be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2 °F (-16.7 °C) when reoffered will be rejected for use under this Specification.

b. Optional temperature verification. As an option to verifying internal product temperature at time of loading, the contractor may request an alternate method utilizing product temperature sensing devices. If this option is selected, a Federal-State supervisor will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in applicable Poultry Programs' instructions for this Specification.

### C. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 C.F.R. Part 70, 9 C.F.R. Part 381, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading required by Articles 54 and 55 of USDA-1 must be performed by a USDA grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of the Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by certificates issued by the USDA grader. The contractor must not ship the

commodity unless informed by the USDA grader that the designated lot or subplot to be shipped meets contract specifications.

## **VI. UNITIZATION**

Each delivery unit of commodity must be unitized (palletized and stretchwrapped) and comply with the following:

### **A. Pallets**

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layer of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to the containers of product.

### **B. Pallet Exchange**

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

## **VII. SHIPMENT AND DELIVERY**

Shipment and delivery must be made in accordance with the Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

### **A. Contract Compliance Stamp**

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A USDA grader, or other authorized personnel under the supervision of the USDA grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

### **B. Grading Certificate**

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the USDA grader, warehouseman, or consignee, as applicable.

## **VII.B.**

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the USDA grader, warehouseman, or consignee, as applicable.

### **C. Loading and Sealing of Vehicles**

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a USDA grader.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to two destinations will not require separation by sealing each drop.

### **D. Delivery Notification**

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate USDA resident grader and furnish applicable information.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a USDA grader are also required for transfers in store.

3. Early Delivery. The contractor may deliver early upon approval of the KCCO. Approval may be obtained by telephoning (816) 926-6068. Approval is contingent on the recipient's concurrence to accept early delivery and upon the USDA grader being available to perform necessary checkloading and final acceptance duties.

**E. Split Deliveries**

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the USDA Grader, at time of shipment, the number of boxes and pounds for each destination.

At the option of the contractor, a purchase unit with two Notices to Deliver (split deliveries) for two different destinations may be delivered on two separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

**VIII. DESTINATION EXAMINATION**

The cost of a destination examination, before or after delivery, by a USDA grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units will be for the account of the contractor. The USDA origin grader will make arrangements for destination examination prior to delivery.

**A. Commodity Requirements**

Before acceptance by consignee, the commodity may be examined by a USDA grader on a spot-check basis for temperature, condition, identity, and when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

**B. Temperature**

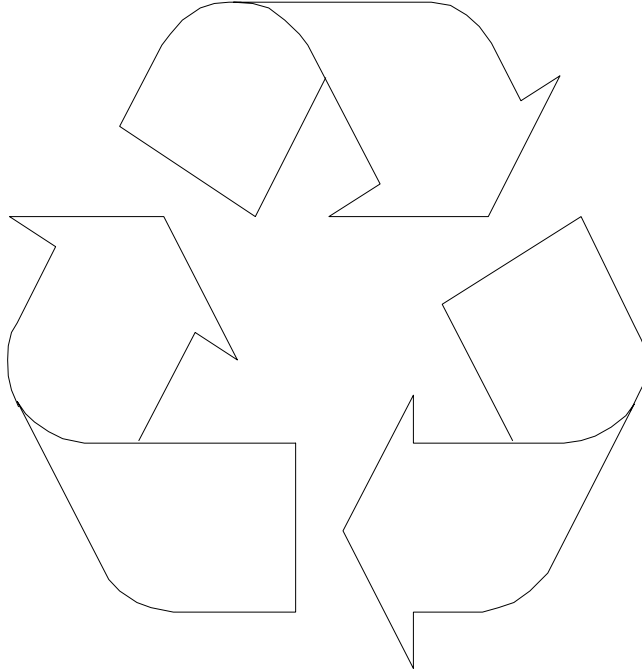
The commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C). Commodity not meeting these requirements will be rejected for use under this Specification.

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D. Michael Holbrook  
Deputy Administrator, Poultry Programs

Attachment

**EXHIBIT 1**  
**“Please Recycle” Symbol and Statement**





**PLEASE  
RECYCLE**

## EXHIBIT 2

### Label Information for Shipping Containers of Frozen Ground Turkey



**Marking Information:** Shipping containers shall be marked substantially as shown below. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The words “GROUND TURKEY,” on each end, must be in letters at least 1 inch (2.54 cm) high. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height. The UPC 14-digit I 2/5 bar code (1 07 15001 01540 9), symbol and code, must be shown in the lower right-hand corner of both side panels. The recycle symbol and statement must be legibly printed somewhere on the surface of each recyclable shipping container.

<p><b>GROUND TURKEY</b></p>			
<p><b>FROZEN GROUND TURKEY</b></p> <p>Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs.</p> <p>Not To Be Sold Or Exchanged.</p> <p>UPC Code</p>		<p><b>KEY POINTS FOR HANDLING FROZEN GROUND TURKEY</b></p> <p><b>WASH AND SANITIZE ALL PREPARATION SURFACES, TOOLS, AND HANDS USED TO PREPARE RAW TURKEY</b></p> <p><b>STORAGE AND SHELF LIFE:</b> Store frozen at 0°F (-17.8°C) or below. Store in original containers and casings. Product quality depends on storage conditions and time of storage. For highest quality, use within 4 months.</p> <p><b>ESTIMATE NEED:</b> Thaw only amount needed for 1 day's use. Avoid leftovers. To estimate needs before removing from freezer, allow 18 pounds 13 ounces (8.60 kg) for 100 2-ounce (57 g) servings of cooked lean poultry.</p> <p><b>THAW:</b> Thaw ground turkey in refrigerator (35-40°F) (1.7-4.4°C). Remove packages from original shipping container and place in a single layer on sheet pans or trays. Allow up to 48 hours to thaw one 10-pound (4.54 kg) package of ground turkey. The center of the package should be thawed, or slightly icy, for easy mixing and to avoid overcooking. Keep thawed ground turkey refrigerated at 40°F (4.4°C) or below until cooked. Do not refreeze.</p> <p><b>COOK:</b> Cook within 24 hours after thawing. Remove ground turkey from casings before preparing. Lightly brush or wipe cooking pan with a small amount of vegetable oil if needed to prevent sticking. Cook ground turkey approximately 20 minutes until a pink color is no longer visible. Hold on a heat-maintained serving line at least 140°F (60°C) for no more than 2 hours.</p>	<p><b>SERVING SUGGESTIONS:</b> Use in making well-seasoned dishes such as Chili, Lasagna, Spaghetti with Meat Sauce, Tamale Pie, and Sloppy Joe.</p> <p><b>LEFTOVERS:</b> Immediately refrigerate leftovers at 40°F (4.4°C) or below. Use within 2 days, heating to at least 165°F (73.9°C).</p> <p style="text-align: center;">Nutrition Facts Panel May Be Placed Here.</p> <p style="text-align: center;">Safe Handling Instructions May Be Placed Here.</p> <p style="text-align: center;"><b>PERISHABLE--KEEP FROZEN</b></p> <p style="text-align: center;"><b>KEEP AT ZERO DEGREE F (-17.8 °C)</b></p> <p style="text-align: center;"><b>OR BELOW</b></p>
		<p><b>GROUND TURKEY</b></p> <p><b>KEEP FROZEN</b></p> <p>4 Casings Net Combined Weight 40 LBS. (18.14 KILOGRAMS)</p>	
		<p>CONTRACT NO. _____</p> <p>DATE PACKED <u>Month, Day, Year</u></p>	

### EXHIBIT 3

#### Label Information for Shipping Containers of Frozen Turkey Burgers



**Marking Information:** Shipping containers shall be marked substantially as shown below. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The words “TURKEY BURGERS,” on each end, must be in letters at least 1 inch (2.54 cm) high. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height. The UPC 14-digit I 2/5 bar code (1 07 15001 01541 6), symbol and code, must be shown in the lower right-hand corner of both side panels. The recycle symbol and statement must be legibly printed somewhere on the surface of each recyclable shipping container.

	<b>TURKEY BURGERS</b>
<b>FROZEN TURKEY BURGERS</b> Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged.  UPC Code	<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><b>KEY POINTS FOR HANDLING TURKEY BURGERS</b></p> <p><b>WASH AND SANITIZE ALL PREPARATION SURFACES, TOOLS, AND HANDS USED TO PREPARE RAW TURKEY</b></p> <p><b>STORAGE AND SHELF LIFE:</b> Store frozen at 0°F (-17.8°C) or below. Store in original containers and packaged bags. Product quality depends on storage conditions and time in storage. For highest quality, use product within 4 months.</p> <p><b>PREPARATION:</b> Burgers should be cooked from the frozen state to prevent moisture loss. Remove from plastic bags and separate from patty paper. Lightly brush or wipe sheet pans with a small amount of vegetable oil if needed to prevent sticking during cooking. Place burgers in a single layer on sheet pans. Burgers with a cube pattern or square indentations should be cooked in oven with pattern side up. Bake until brown and cooked throughout, until a pink color is no longer visible.</p> <p>Suggested instructions are:            Deck Oven 350 °F (176.7 °C) 10 to 20 min.            Convection Oven 350 °F (176.7 °C) 8 to 10 min.</p> <p><b>SERVING:</b> Serve as soon as possible. Holding on a steam table or in a holding cabinet will cause them to dry and toughen. Hold on a heat-maintained serving line at least 140 °F (60 °C) for no longer than 2 hours.</p> <p><b>YIELD:</b> Each 3-ounce (85.05 g) burger yields about 2 ounces (56.7 g) of cooked lean meat.</p> </div> <div style="width: 45%;"> <p><b>LEFTOVERS:</b> Immediately refrigerate any leftovers at 40 °F (4.4 °C) or below. Use any leftovers within 2 days, always being sure to heat to at least 165 °F (73.9 °C).</p> <p style="text-align: center;">Nutrition Facts Panel May Be Placed Here.</p> <p style="text-align: center;">Safe Handling Instructions May Be Placed Here.</p> <p style="text-align: center;"><b>PERISHABLE--KEEP FROZEN</b></p> <p style="text-align: center;"><b>KEEP AT ZERO DEGREE F (-17.8 °C)</b></p> <p style="text-align: center;"><b>OR BELOW</b></p> </div> </div>
<b>FROZEN TURKEY BURGERS</b> Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged.  UPC Code	<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><b>TURKEY BURGERS</b></p> <p><b>KEEP FROZEN</b></p> <p>___ Bags Net Combined Weight            36 LBS. (16.33 KILOGRAMS)</p> </div> <div style="width: 45%;"> <p style="text-align: center;">             CONTRACT NO. _____            DATE PACKED <u>Month, Day, Year</u> </p> </div> </div>

## EXHIBIT 4

### Label Information for Shipping Containers of Frozen Turkey Sausage

**Marking Information:** Shipping containers shall be marked substantially as shown below. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The words “TURKEY SAUSAGE,” on each end, must be in letters at least 1 inch (2.54 cm) high. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height. The UPC 14-digit I 2/5 code (1 07 15001 01542 3), bar and code, must be shown in the lower right-hand corner of both side panels. The recycle symbol and statement must be legibly printed somewhere on the surface of each recyclable shipping container.

<p><b>TURKEY SAUSAGE</b></p> 	
<p><b>FROZEN TURKEY SAUSAGE</b></p> <p>Ingredients:</p> <p><b>KEY POINTS FOR HANDLING</b></p> <p><b>Wash And Sanitize All Work Surfaces, Tools, And Hands Used</b></p> <p><b>STORING:</b> Store frozen at 0 °F (-17.8 °C) or below. Store in original casings.</p> <p><b>THAW:</b> Thaw only amount needed for 1 day's use. Remove packages from original shipping containers and place in a single layer on sheet pans or trays. Thaw in refrigerator (35-40 °F) (1.7-4.4 °C) up to 48 hours for one 3- or 5-pound (1.36 or 2.27 kg) casing of turkey sausage. The center of the package should be thawed, or slightly icy, for easy mixing and to avoid overcooking. Keep thawed turkey sausage refrigerated at 40 °F (4.4 °C) or below until cooked. Do not refreeze.</p> <p><b>PREPARATION:</b> Remove turkey sausage from casings before preparing. Can be formed into links or patties, if desired as a breakfast item after thawing.</p> <p><b>COOKING:</b> Cook within 24 hours after thawing. Lightly brush or wipe cooking pan with a small amount of vegetable oil to prevent sticking. Cook turkey sausage approximately 20 minutes until a pink color is no longer visible. Hold on a heat-maintained serving line at 140 °F (60 °C).</p> <p><b>SERVING SUGGESTIONS:</b> Serve as Tacos or with Soft Flour Tortillas and salsa. Or use in making Chili, Lasagna, Spaghetti Meat Sauce, or Pizza topping.</p>	<p><b>YIELD:</b> A 1.60 ounce (45.36 g) serving of turkey sausage provides 1 ounce (28.35 g) of cooked turkey meat. One 30 pound (13.61 kg) shipping container provides a minimum 150 2-ounce (56.70 g) servings.</p> <p><b>LEFTOVERS:</b> Immediately refrigerate leftovers at 40 °F (4.4 °C) or below. Use within 2 days, heating to at least 165 °F (73.9 °C).</p> <p>Nutrition Facts Panel May Be Placed Here.</p> <p>Safe Handling Instructions May Be Placed Here.</p> <p><b>PERISHABLE--KEEP FROZEN</b></p> <p><b>KEEP AT ZERO DEGREE F (-17.8 °C)</b></p> <p><b>OR BELOW</b></p>
<p><b>FROZEN TURKEY SAUSAGE</b></p> <p>Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs.</p> <p>Not To Be Sold Or Exchanged.</p> <p>UPC Code</p>	<p><b>FROZEN TURKEY SAUSAGE</b></p> <p>Ingredients: Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs.</p> <p>Not To Be Sold Or Exchanged.</p> 
<p><b>TURKEY SAUSAGE</b></p> <p><b>KEEP FROZEN</b></p> <p>CONTRACT NO. _____</p> <p>DATE PACKED <u>Month, Day, and Year</u></p> <p>___ Bags Net Combined Weight 30 LBS. (13.61 KG)</p>	